

Date: Friday, 14/07/2006 2:46:03 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CABLE GUARD
 Job Number : 27907
 Estimate Number : 12459
 P.O. Number : N/A Part Number : D29167
 This Issue : 14/07/2006 S.O. No. : N/A Drawing Number : D2916 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : 13/07/2006 Type : MACHINED PARTS Drawing Revision : B
 Previous Run : N/A Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 10/08/2006 Qty: 12 Um: Each
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-06-19 JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET	
2.0	MUHMWB10	UHMW 1" Black
	Comment: Qty.: 0.2600 sf(s)/Unit Total : 3.12 2.6000 sf(s) UHMW 1" Black Batch # 101253 SAD 06:08:10 12	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 06:08:10 12	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK J.F. 06/08/14 12	
5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 BATCH: 101253 1- Mill as per Folio FA2916-7 Rev: A & Dwg D2916 Rev: B 2-Deburr per dwg D2916 J.F. 06/08/14 12	

Date: Friday, 14/07/2006 2:46:04 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 27907

Part Number: D29167

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/08/14 12

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 06/08/15 12

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S1373

LB 06/08/16 (12)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/08/17 (12)

Job Completion



C 206/08/17

Date: Thursday, 7/13/2006 3:38:19 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CABLE GUARD
Job Number :	27907		
Estimate Number :	12459		
P.O. Number :		Part Number :	D29167
This Issue :	7/13/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2916 REV B
First Issue :	//	Project Number :	N/A
Previous Run :		Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	8/10/2006
Written By :		Qty:	10 Um: Each
Checked & Approved By :	<i>06-07-13</i>		
Comment :	Est Rev:A New Issue 06-06-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: _____

For (1) D2916-7 21.37" x 1.75" x 1.00" (

Tolerance for all measurements is (+0.030/-0.000)

Material: Black UHMW(MUHMWB10)

Possible Supplier: GE Polymers Material release note is required

*cut on waterjet**MUHMWB10*

2.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

2.0 QC

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

4.0 HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

BATCH: _____

1- Mill as per Folio FA2916-7 Rev: _____ & Dwg D2916 Rev: _____

2-Deburr per dwg D2916

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/13/2006 3:38:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 27907

Part Number: D29167

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

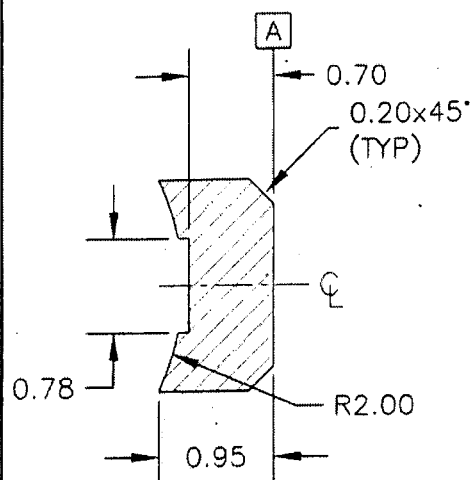
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

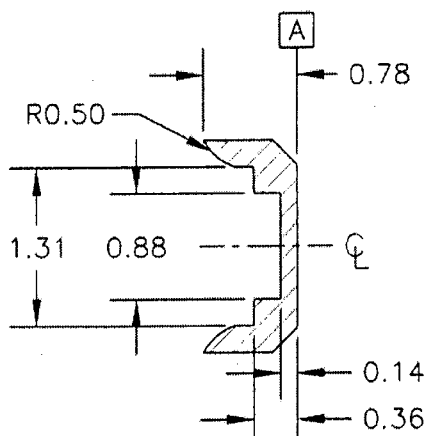
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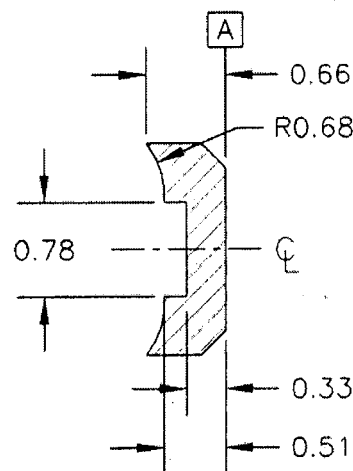
DESIGN #		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #		APPROVED #		DRAWING NO. D2916	
				REV. B SHEET 1 OF 2	
DATE 00.02.24			TITLE CABLE GUARD		
			SCALE 1:6		
A	99.09.29		NEW ISSUE		
B	00.02.24		ADD K-K FOR D2521 COMPATIBILITY		



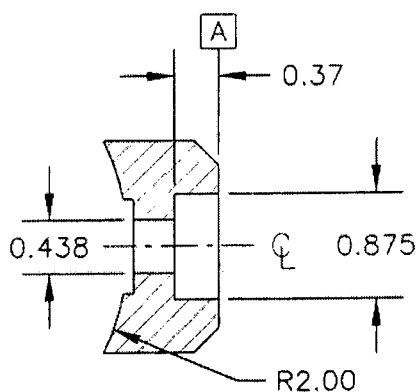
SECTION A-A
(SCALE 2:3)



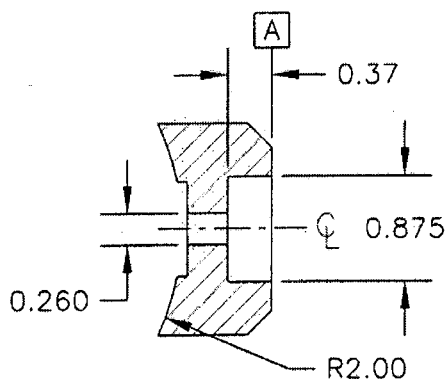
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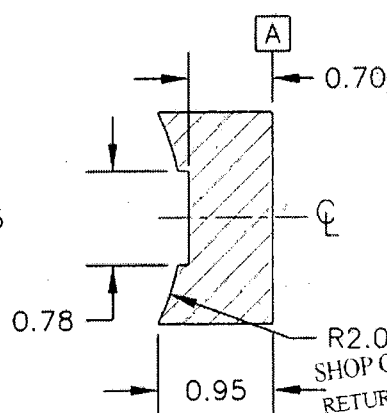
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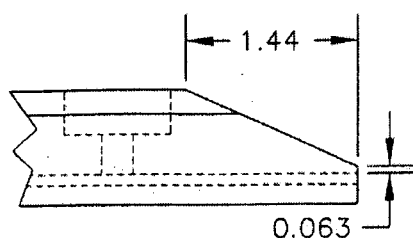
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SECTION E-E
(SCALE 2:3)

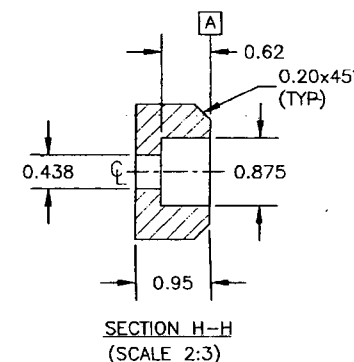
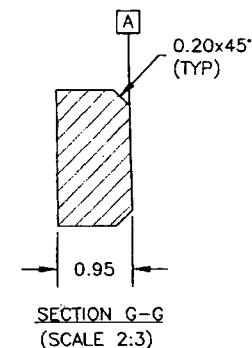
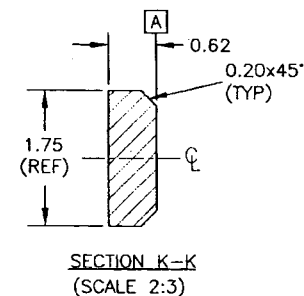
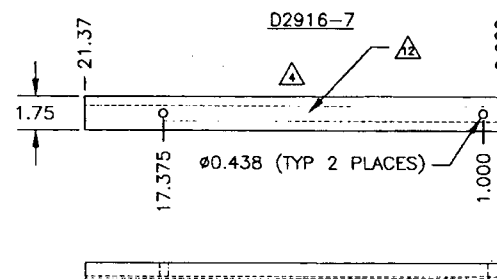
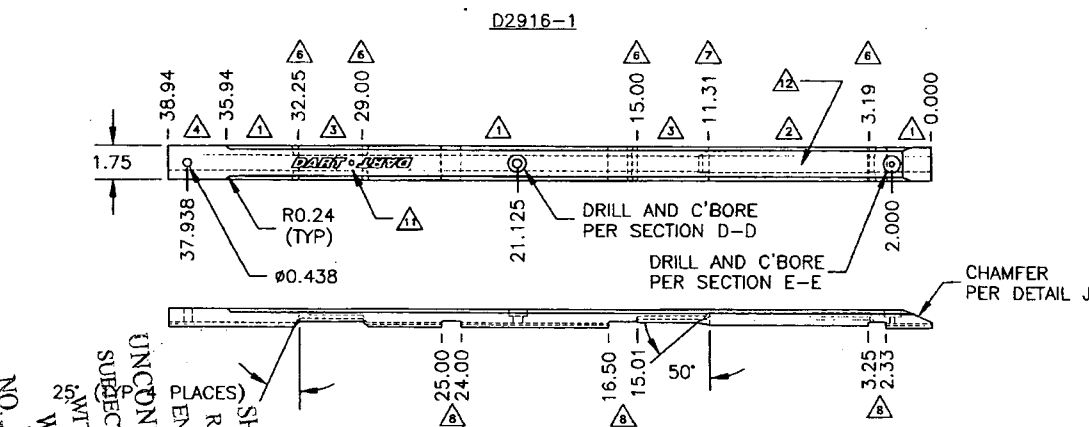
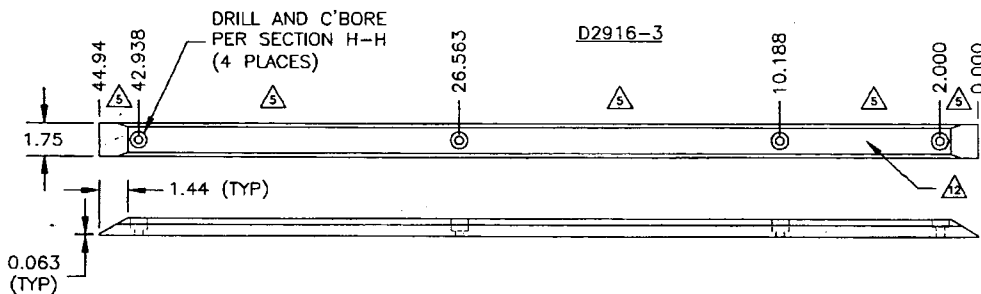
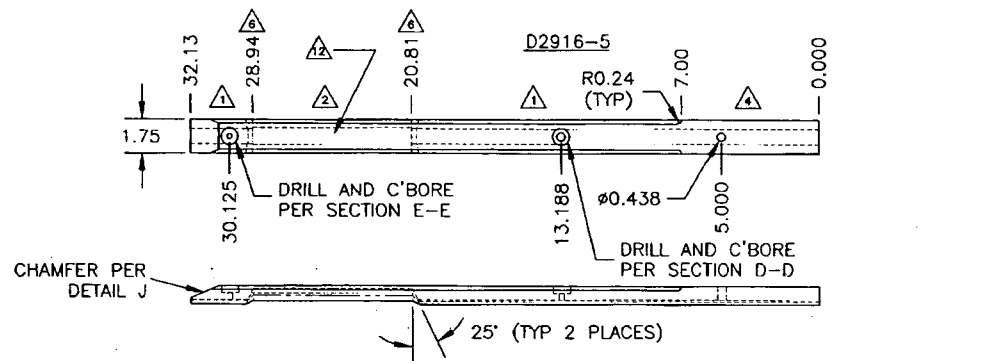


ENGINEERING
SECTION FIVE CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27907



DETAIL J
(SCALE 2:3)

RELEASED
000 02 25 DS



NOTES:

- 1) MACHINE CONSTANT SECTION A-A
- 2) MACHINE CONSTANT SECTION B-B
- 3) MACHINE CONSTANT SECTION C-C
- 4) MACHINE CONSTANT SECTION F-F
- 5) MACHINE CONSTANT SECTION G-G
- 6) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 7) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 8) MACHINE SLOT PER SECTION K-K WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
- 9) MATERIAL: UHMW BLACK PER SPEC CONTROL DWG D2689
- 10) BREAK ALL UNMARKED RADII 0.020 TO 0.040
- 11) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250.
- 12) ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010.
- 13) ALL HOLES DRILLED ON CENTERLINES
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 15) ALL DIMENSIONS ARE IN INCHES

RELEASED

DESIGN #	DRAWN BY	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2916
DATE	TITLE	SCALE
00.02.24	CABLE GUARD	1:6

NO. 27907
25°
WORK ORDER
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
RETURN TO
ENGINEERING
PLACES)
SHOP COPY
WITH OUT NOTICE

